

# Work Order ID 60824

Friday, July 23, 2010 10:43:09 AM



Page 1

Item ID: D4151-5

Accept



Setup Start



Revision ID:

Item Name: Fwd Basket Instl Stud

Stop



Start Date: 7/23/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-7-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4151

B

110

0.00



Doosan

Memo

0.00

Doosan Lathe

1-Mill as per folio FA953 & dwg,  
FOLIO REV: N/A  
DWG REV: B

SL 10/07/25

4

2-GRIND .13" RAD MANUALLY

3-Deburr as required

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/07/25

4

4

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

**Work Order ID 60824**

Friday, July 23, 2010 10:43:09 AM

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Item ID: D4151-5

Accept

Revision ID:

Item Name: Fwd Basket Instl Stud

Start Date: 7/23/2010 Start Qty: 4.00

Required Date: 7/30/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DTP 10/07/25

4

8

140

Identify as per dwg & Stock Location: *Sylve*

0.00



Packaging

Memo

0.00

Packaging

GA

10-7-26 (4)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/26 (4)  
10-7-26 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, July 23, 2010 10:43:13 AM

Page 1

Work Order ID: 60824

Parent Item: D4151-5

Parent Item Name: Fwd Basket Instl Stud





Start Date: 7/23/2010

Required Date: 7/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000  303 Round Bar 1.00		Purchased	No				f	17.4460	0.25 	1.052632			

Location

Loc Qty

Loc Code

MAT028

17.446

113325

17.446

1.05 SL 10/07/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 60824
<b>Description:</b> End basket instl stud (Lower)		<b>Part Number:</b> D4151-5
<b>Inspection Dwg:</b> D4151	<b>Rev:</b> B	<b>Page 1 of 1</b>

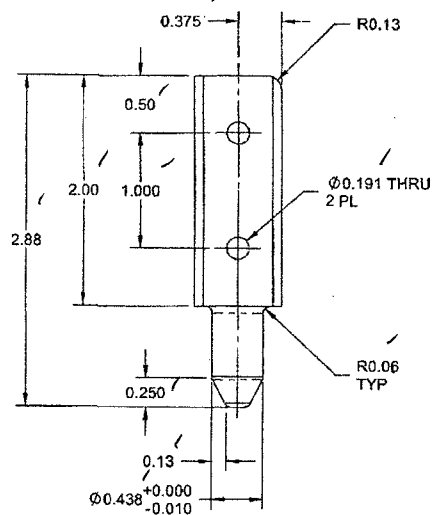
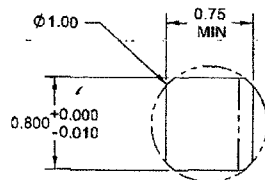
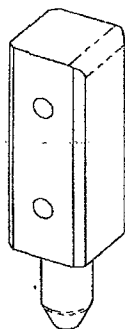
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	$\pm .030$	.999	✓			
.800	$\pm .010$	.794	✓			
.750	$\pm .030$	.754	✓			
.375	$\pm .010$	.375	✓			
.50	$\pm .030$	.500	✓			
1.000	$\pm .010$	.999	✓			
2.00	$\pm .030$	2.000	✓			
2.88	$\pm .030$	2.881	✓			
.250	$\pm .010$	.250	✓			
.438	$\pm .010$	.435	✓			
.13	$\pm .030$	.130	✓			
5.06	$\pm .030$	.060	✓			
Ø .191	$\pm .005$	.191	✓			
5.13	$\pm .030$	.130	✓			

<b>Measured by:</b> JL	<b>Audited by:</b> DJP	<b>Preliminary Approval:</b>
<b>Date:</b> 10/07/25	<b>Date:</b> 10/07/25	<b>Date:</b>

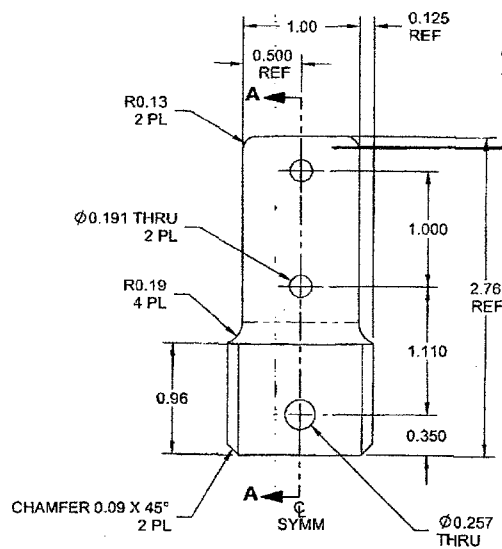
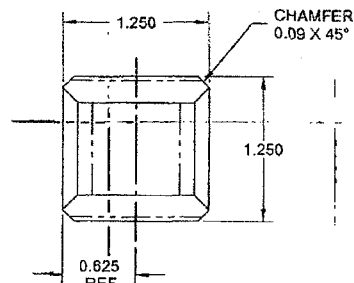
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

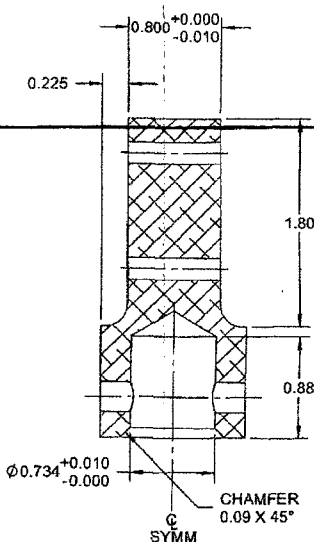


**D4151-5 FWD BASKET INSTL STUD (LOWER)**

*w/o boss*



**D4151-7 FWD EYEBOLT RECEIVER (UPPER)**



**SECTION A-A**

**RELEASED**  
2010-07-16

**NOTES:**

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs  
-7: 0.70 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4151</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET FWD HARDPOINT</b>	NTS
DATE	10:07:05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	